

Date: Wednesday, 11/30/2005 8:10:29 AM
 User: Linda Lacelle

Process Sheet

| | | | |
|----------------------------------|---------------------------------------|-------------------------|-----------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : BEAM ASSEMBLY |
| Job Number | : 25024 | | |
| Estimate Number | : 10407 | | |
| P.O. Number | : N/A | Part Number | : D3173041 |
| This Issue | : 11/30/2005 | S.O. No. | : N/A |
| Prsht Rev. | : NC | Drawing Number | : D3173 REV B |
| First Issue | : N/A | Project Number | : N/A |
| Previous Run | : 25024 | Drawing Revision | : B |
| | Type | Material | : N/A |
| | : MACHINED PARTS | Due Date | : 12/7/2005 |
| Written By | : See comment below | Qty: | 4 |
| Checked & Approved By | : See comment below | Um: | Each |
| Comment | : Est. A 02.12.05 New issue KJ/RF | | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|--------------------|-------------------------|
| 1.0 | M6061T6TR40X20W125 | 6061-T6 Rect Tube W.125 |
|-----|--------------------|-------------------------|



Comment: Qty.: 4.9219 f(s)/Unit Total: 19.6875 f(s)
 6061-T6 Rect Tube W.125
 Material: 6061-T6 (QQ-A-200/8) Rect. Tube 4" x 2" x 0.125 thick
 (M6061T6TR4.0x2.0W125)
 Batch M19265 M8 05/12/10 4

| | | |
|-----|----------|----------|
| 2.0 | BAND SAW | BAND SAW |
|-----|----------|----------|



Comment: BAND SAW
 Cut blank: 56" long
 Machine holes as per Folio FA295 and Dwg D3173
 Identify as D3173-1 M8 05/12/10 4

| | | |
|-----|-------|--------------------------------|
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1
 Machine holes as per Folio FA295 and Dwg D3173 Identify as D3173-1 M8 05/12/10 4

| | | |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE M8 05/12/10 4

| | | |
|-----|-----|--------------|
| 5.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK M8 05/12/12 4

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEAM ASSEMBLY

Job Number: 25024

Part Number: D3173041

Job Number:



Seq. #: Machine Or Operation:

Description :

MT

4

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

MB

05/12/12

4

7.0

QCS

SECOND CHECK



Comment: SECOND CHECK

9ml 05/12/12

4

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Drill Ø0.316" holes as per Dwg D3173
C'sink holes as per Dwg D3173

FF

05/12/13

4

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

05.12.13

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

FF

05.12.14

4

11.0

D3178041

Nut Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
Nut Plate
Pick K10017. Install Nut Plate as per Dwg D3173. D3178-041 is included in K10017 BOM.
Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|---------------|
| 2 | D3178-041 | Nut Plate | <i>B22409</i> |

FF

05/12/15

12.0

MS20601AD4W4

Rivet



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)
Rivet
Pick:

| Qty | Part Number | Description | Batch |
|-----|--------------|-------------|--------------|
| 8 | MS20601AD4W4 | Rivet | <i>M1561</i> |

M19278

23a

9a

FF 05/12/15

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Job Number: 25024

Part Number: D3173041

Job Number:



Seq. #: Machine Or Operation: Description :

13.0

QC5

INSPECT WORK TO CURRENT STEP



05-12-16

4

Comment: INSPECT WORK TO CURRENT STEP

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref: 4.3.5.1) per QSI 005 4.3
Ensure Nut Plate thread is covered.

05 12 19

4

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

05/12/20

4

16.0

D3175041

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Mounting Lug

Assemble per Dwg D3173. Install Mounting Lug as per Dwg D3173. D3175-041 is included in K10017 BOM.

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 2 | D3175-041 | Mtg Lug | B24409 |

FF 05/12/20

4

17.0

AN35A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Bolt

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 8 | AN3-5A | Bolt | M15205 |

FF 05/12/20

4

18.0

AN523A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|---------------|
| 2 | AN5-23A | Bolt | M12755/m19278 |

4x 4x

FF 05/12/20

4

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Drawing Name: BEAM ASSEMBLY

Job Number: 25024

Part Number: D3173041

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|------|-----------|--------|
| 19.0 | AN960JD10 | Washer |
|------|-----------|--------|



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)
Washer

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 8 | AN960JD10 | Washer | M16066 |

FF 05/12/20

4

| | | |
|------|------------|--------|
| 20.0 | AN960JD516 | Washer |
|------|------------|--------|



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)
Washer

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 4 | AN960JD516 | Washer | M18254 |

FF 05/12/20

4

| | | |
|------|-----------|-----|
| 21.0 | MS21042L5 | Nut |
|------|-----------|-----|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
Nut

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 2 | MS21042L5 | Nut | M17653 |

FF 05/12/20

4

| | | |
|------|-------------|-------------------------------|
| 22.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|------|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble per Dwg D3173.
Install Mounting Lug as per Dwg D3173. D3175-041 is included in K10017 BOM.

FF 05/12/20

4

| | | |
|------|-----|------------------------------|
| 23.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|------|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

05-12-20

4

| | | |
|------|-------------|-----------------------|
| 24.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|------|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1
Identify as D3173-041 and Pack with D130-701-041
Location: 91

05/12/20

(4)

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEAM ASSEMBLY

Job Number: 25024

Part Number: D3173041

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

④
RP 03/12/20

Job Completion



u



| | | | |
|-------------------------------|--------------------------------|--|------------------------|
| DESIGN <i>CP</i> | DRAWN BY <i>CP</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3173 | REV. B SHEET 1 OF 3 |
| DATE 03.01.07 | | TITLE BEAM ASSEMBLY | SCALE NTS |
| A | 02.12.03 | NEW ISSUE | |
| B | 03.01.07 | REMOVE PIP PINS | |

PARTS LIST

| QTY | PART NUMBER | DESCRIPTION |
|-----|--------------|---------------|
| X | D3173-041 | BEAM ASSEMBLY |
| 1 | D3173-1 | BEAM |
| 2 | D3175-041 | MOUNTING LUG |
| 2 | D3178-041 | NUT PLATE |
| 8 | AN960JD10 | WASHER |
| 4 | AN960JD516 | WASHER |
| 2 | MS21042L5 | NUT |
| 8 | MS20601AD4W4 | RIVET |
| 8 | AN3-5A | BOLT |
| 2 | AN5-23A | BOLT |

NOTES

D3173-1 BEAM:

- 1) PART IS SYMMETRICAL ABOUT CENTERLINE
- 2) MATERIAL: 6061-T6 RECTANGULAR TUBING, 4" x 2" x 0.125" WALL (QQ-A-200/8)
(REF DART SPEC. M6061T6TR4.0x2.0W125)
- 3) BREAK ALL SHARP EDGES 0.010-0.020
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3 OUTSIDE ONLY
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

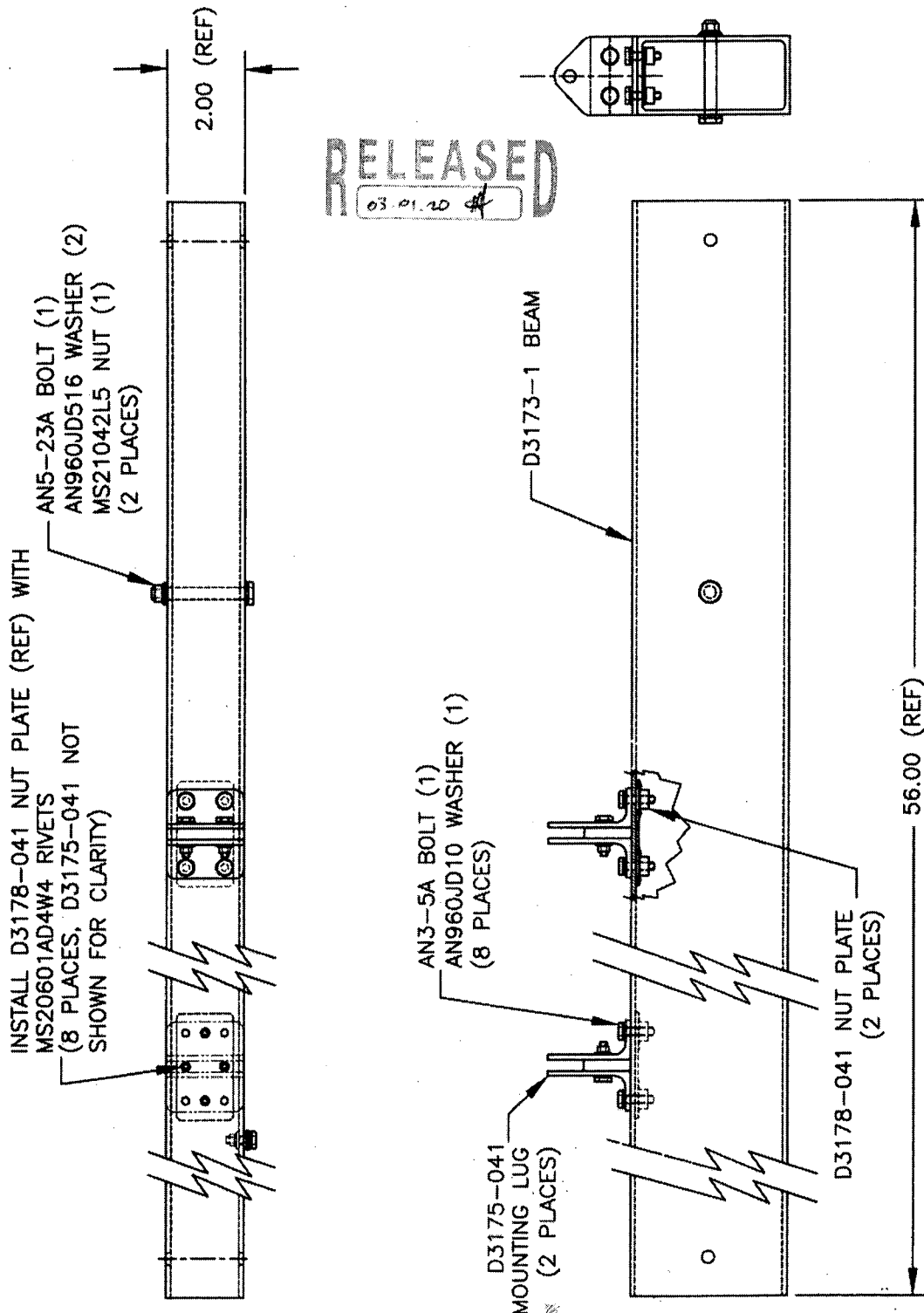
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| CHECKED | APPROVED | DRAWING NO. D3173 | REV. B SHEET 2 OF 3 |
| DATE 03.01.07 | | TITLE BEAM ASSEMBLY | SCALE 1:4 |



D3173-041 BEAM ASSEMBLY

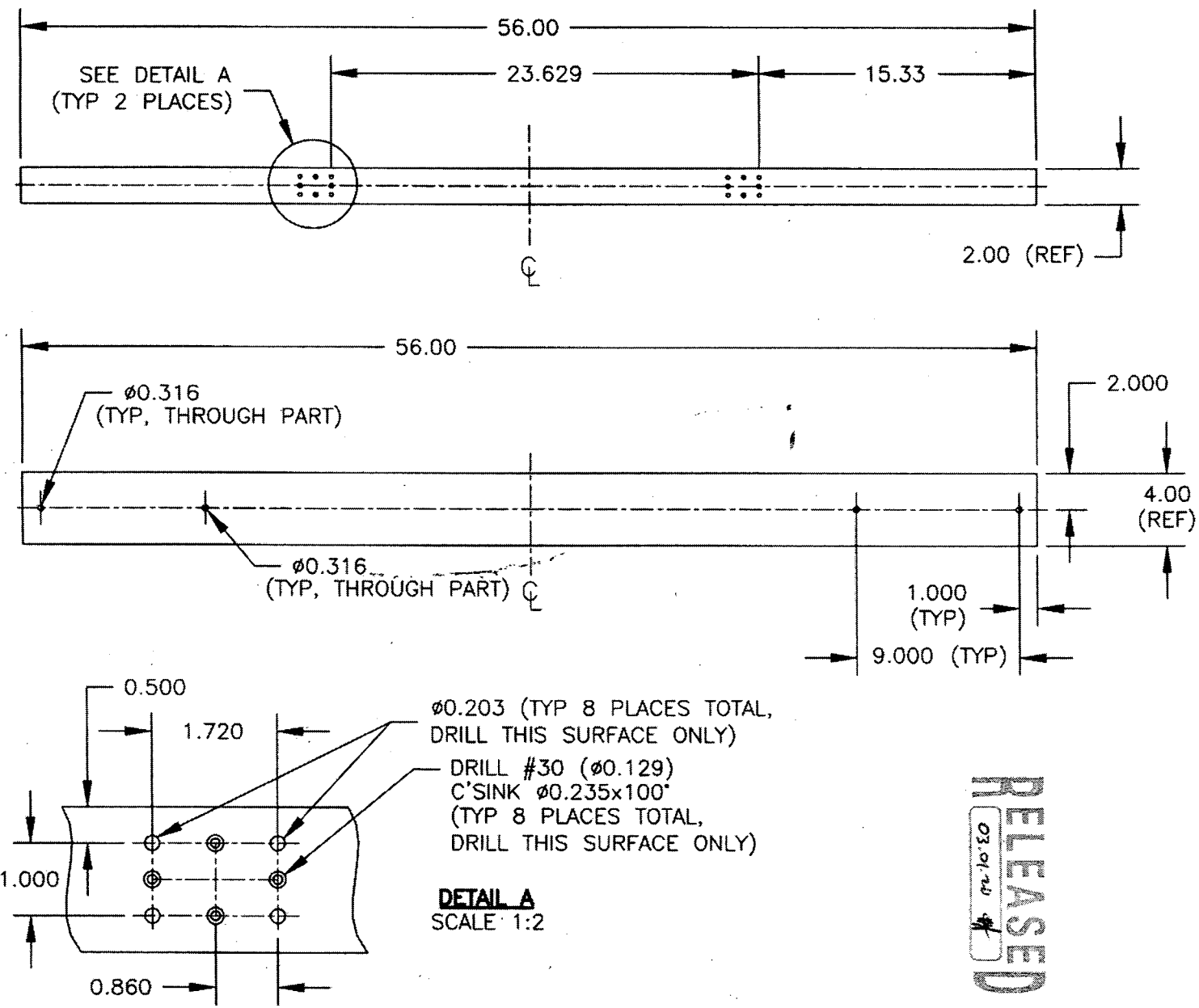
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| CHECKED | APPROVED | DRAWING NO. D3173 |
| DATE 03.01.07 | TITLE BEAM ASSEMBLY | REV. B SHEET 3 OF 3 SCALE 1:8 |

D3173-1 BEAM



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